

# Work Order ID 55341

January 13, 2010 10:27:19 AM

Page 1

Item ID: D2332-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lid Prop Assembly 6.69" long

Start Date: 1/13/10 Start Qty: 6.00

Cust Item ID:

Required Date: 1/20/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *PP*

Date: *10-1-13* Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00



Small Fab

Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

*=> m. 10/02/04*

*6X*

110

0.00



Brake NC

Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012  
( need 2 per ass'y)

*=> m. 10/02/04*

*6X*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Small Fab

Memo

0.00

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459  
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

130

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

140

0.00



Large Fab

Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)  
\*\*\*\*\*ensure nothing is inside of tube before welding\*\*\*\*\*

S.S Rod batch: M108160

M-h 10/01/04

D2332-5 - 5 10/02/08 x6  
D2332-7 - 5 10/02/08 x6  
D2332-1 - 5 10/02/08 x6  
D2332-13 - 5 10/02/08 x6

EL 10-2-9

x6

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10.02.09 (16)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Siderlog

(16)

170

0.00



Small Fab

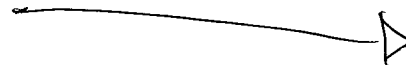
Memo

0.00

Small Fab

1- Tumble

2- Assemble as per dwg D2332



10-5-11

(6)

10/02/16 (6)

W/O:		WORK ORDER CHANGES					
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Reference:

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Approvals: Process Plan: Date:

Tooling: Date:

Stop

QC: Date:

SPC (Y/N): Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

8/10/2016

(76)

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location Sra

0.00

Packaging

Memo

0.00

Packaging

10-2-16

(65)

200

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/02/16

WUF

10-2-16

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# Picklist Print

January 13, 2010 10:27:23 AM

Page 1

Work Order ID: 55341

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF  
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R.250		Purchased	No			100	f	23.4328	0.6316			



304 SS Round bar .250

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

23.4328

107387

23.4328

100

f

56.1143

2.7158

M304TR1.000W.049

Purchased

No



304 RD Tube 1.00 x .049W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

56.1143

108756

14.92

111457

41.1943

110

f

202.7814

7.8947

M304TR0.500W.035

Purchased

No



304 RD Tube .500 x .035W

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

202.7813674

108250

2.23

111704

31.6682737

112187

43.9830937

112800

124.9

M111097

M-1 \*  
0.6316 10/02/04

M-1 \*  
2.7158 10/02/04

M-1 \*  
10/02/04  
4X  
5X  
3X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 55341

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long



Start Date: 1/13/10

Required Date: 1/20/10

Comments: IPP: B002.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF  
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-4A		Purchased	No			170	Each	117.0000	6.0000			
												
Bolt												

*ES 10/02/16*

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST		117	
101291		3	
106918		1	
108138		56	
111295		57	

AN960JD416L

Purchased

No

170

Each

793.0000

18.0000



Washer



*ES 10/02/16*

<u>Warehouse</u>	<u>Loc</u>	<u>Qty</u>	<u>Loc Code</u>
<u>Location</u>			
Main Warehouse			
ST		793	
105078		4	
107008		54	
108583		38	
110153		297	
112492		400	

QSI 017  
NAS1149D0416 J  
M10538 (18x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Comments: IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF  
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			170	Each	3,915.000	6.0000			



Nut



*9510/02/16*

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST	3915	
102552	6	
104248	6	
110507	184	
111827	2719	
113422	1000	
15924	0	

<i>6</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

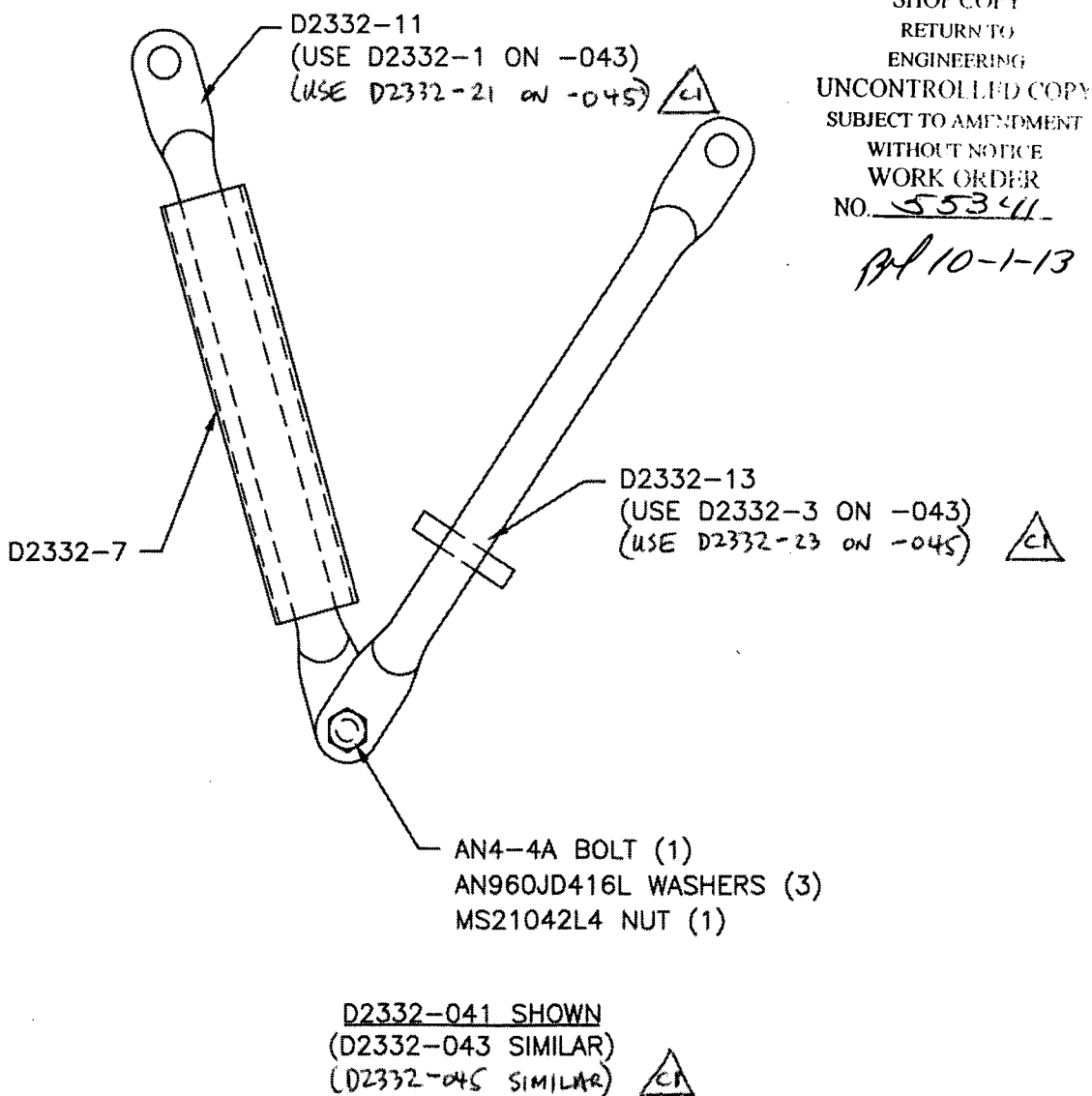
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	<i>[initials]</i> 03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED  
03.07.04 *[initials]*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55341

*PA 10-1-13*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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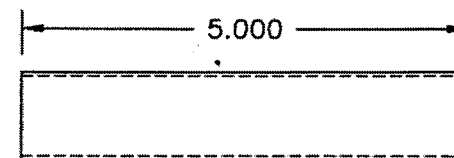


**DART**

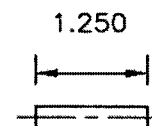


DESIGN	DRAWN BY	DART AEROSPACE LTD
<del>11</del>	<del>11</del>	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<del>11</del>	<del>11</del>	D2332
DATE	TITLE	SCALE
03.07.03	LID PROP ASSEMBLY	1:2

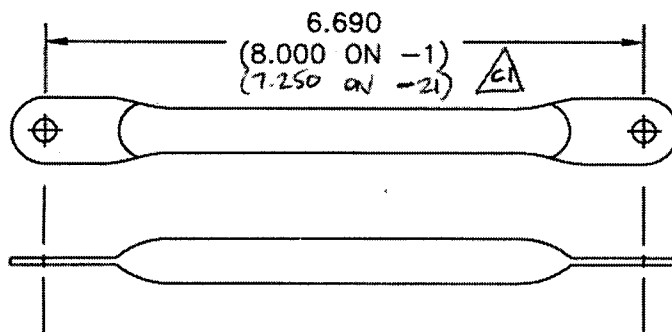
C	03.07.03	MAKE - 0.11 PROP 6.69" LONG (STD)
C1	03.08.06	MAKE - 0.43 PROP 8.00" LONG (ORT)
		ADD - 0.45 PROP (7.25" LONG)



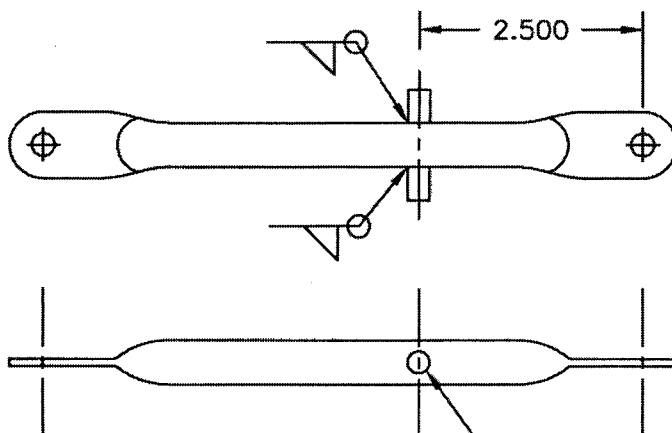
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP  
(D2332-1 SIMILAR)



DRILL 1/4 HOLE FOR D2332-5

D2332-13  
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)  
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED  
03.07.04

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